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TITLE: METHOD OF MANUFACTURING CARBODY PANEL

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INVENTOR-INFORMATION:

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ABSTRACT:

**PROBLEM TO BE SOLVED:** To adjust a metal plate on which differential thickness parts are formed into the metal plate having uniform material characteristic by annealing and to prevent strain due to heating.

**SOLUTION:** This manufacturing method of a carbody panel consists of a metal plate setting stage for setting a metal plate between upper and lower rolls of a rolling means, a clamping stage for clamping both ends of the set metal plate, a tension imparting stage for imparting constant tension to the metal plate, a differential thickness part forming stage for forming differential thickness parts by rolling, an annealing stage for annealing each differential

thickness part under prescribed heating conditions by moving the metal plate a plurality of times within a range of every differential thickness part by a linear heating means corresponding to every differential thickness parts after continuously feeding the formed metal plate to a heating device provided on a conveying line and stopping it in a prescribed position and a panel press-forming stage for forming the annealed metal plate into a carbody panel with a press.

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